



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D2940-1
Job Sheet 178406



Part No: D2940-1

Job Qty: 12 ea

Part Name: Support



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/31/18

Job Tracking No:

Due Date: 6/15/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV C IPP C 02.11.26 Reformat; Added P/O KJ IPP Rev:D Added priming as per Rev B 07-04-30 JLM
IPP E 08.03.19 Re-format Ec verified by DD IPP Rev:F 08-10-22 add qc14 DD verified by:EC IPP Rev:G
11.08.04 as per dwg rev.C DD verf:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea		6/15/18	0.00	0.00	Start Up Machining-1		2nd 18/06/18
100	CNC Vertical Machining	12 pcs		6/15/18	0.32	28.57	HAAS1-2		2nd 18/06/18
110	QC	12 pcs		6/15/18	0.00	0.00	QC2 Machining-1		2nd 18/06/18
120	QC	12 pcs		6/15/18	0.00	0.00	QC8 Machining-1		2nd 18-06-18
130	Crosstubes	12 pcs		6/15/18	0.00	1.50	Crosstubes-2		2nd 18/06/2018
140	QC	12 pcs		6/15/18	0.00	0.00	QC5		2nd 18-06-18
170	Packaging	12 pcs		6/15/18	0.00	0.00	Packaging3-1 LG051		2nd 18-6-18
180	QC21-SA	12 Ea		6/15/18	0.00	0.00	QC21		2nd 18-6-18

Part Op 100 - 1-Machine as per Folio FA079

Descriptions: 130 - Per note 8 on page 1 of dwg D2940, Prep inner concave surface of support and apply 3M Scotch Weld as per dwg.

170 - LOCATION : LG052

M 138676
exp 11/18

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
DSK081	D2940-1 Turning Detail	6 Ea (.5 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	DSK081	6	1	0



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S079508



Part: D2940-1

Job No: 178406

Serial No/Batch: S079508

Revision:

Inspector:

Exp Date:

Instructions:

Date: 06/10/18

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Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	3.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
2	3.250 Support	0.490Inches + 0.020 - 0.000	0.510 0.490		
3	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
4	3.250 Support	3.510Inches + 0.020 - 0.000	3.530 3.510		
5	3.250 Support	1.633Inches + 0.040 - 0.000	1.673 1.633		
6	3.250 Support	1.493Inches + 0.020 - 0.000	1.513 1.493		
7	3.250 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
8	3.250 Support	0.188Inches + 0.005 - 0.000	0.193 0.188		
9	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
10	3.250 Support	2.518Inches + 0.020 - 0.000	2.538 2.518		
11	3.250 Support	0.040Inches + 0.020 - 0.000	0.060 0.040		
12	3.250 Support	0.010Inches + 0.010 - 0.000	0.020 0.010		
13	3.250 Support	0.140Inches + 0.020 - 0.000	0.160 0.140		
14	3.250 Support	0.350Inches + 0.100 - 0.000	0.450 0.350		
15	3.250 Support	0.240Inches + 0.020 - 0.000	0.260 0.240		
16	3.250 Support	0.150Inches + 0.020 - 0.000	0.170 0.150		
17	3.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
18	3.250 Support	101.640Inches + 4.000 - 0.000	105.640 101.640		
19	3.250 Support	0.260Inches + 0.007 - 0.000	0.267 0.260		
20	3.250 Support	0.053Inches + 0.020 - 0.000	0.073 0.053		
21	3.250 Support	4.118Inches + 0.020 - 0.000	4.138 4.118		

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DART AEROSPACE LTD		Work Order: 178406
Description: Ø3.250 Support		Part Number: D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION DIMENSION SHEET

☒ First Article ☐ Prototype

				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	5
HAAS Section								
AA	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AB	0.490	0.510		0.500	0.500	0.500	0.500	0.500
AC	0.140	0.160		0.150	0.150	0.150	0.150	0.150
AD	3.510	3.530		3.510	3.510	3.518	3.517	3.520
AE	1.633	1.673		1.659	1.659	1.660	1.656	1.658
AF	1.493	1.513		1.512	1.512	1.504	1.508	1.504
AG	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AH	0.188	0.193		0.188	0.188	0.188	0.188	0.188
AI	0.140	0.160		0.152	0.152	0.150	0.150	0.150
AJ	2.518	2.538		2.530	2.530	2.525	2.528	2.530
AK	0.040	0.060		0.050	0.050	0.050	0.050	0.050
AL	0.010	0.020		0.010	0.010	0.010	0.010	0.010
AM	0.140	0.160		0.158	0.158	0.160	0.159	0.159
AN	0.350	0.450		0.375	0.375	0.375	0.375	0.375
AO	0.240	0.260		0.250	0.250	0.250	0.250	0.250
AP	0.150	0.170		0.150	0.150	0.151	0.154	0.155
AQ	0.053	0.073		0.0625	0.0625	0.0625	0.0625	0.0625
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		0.261	0.261	0.261	0.261	0.261
AT	0.053	0.073		0.0625	0.062	0.062	0.062	0.062
AU	4.118	4.138		4.131	4.131	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by: <i>guk</i>	Date: 18/06/10
Audited by: <i>A.P.</i>	Date: 18-06-12
Prototype Approval:	Date:

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
B	07.05.08	Dwg Rev. updated	KJ/JLM	
C	07.07.18	Dimension AS revised	KJ/JLM	
D	08.04.22	Reformat	KJ/JLM	
E	12.01.31	Dwg Rev. updated	KJ	

DART AEROSPACE LTD		Work Order:	178906
Description: Ø3.250 Support		Part Number:	D2940-1
Inspection Dwg: D2940	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION DIMENSION SHEET

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				Record Actual Dimensions				
Dim	Min	Max	Go/No Go Gauge	6x	7x	8x	9x	10x
HAAS Section								
AA	0.240	0.260		.250	.250	.250	.250	.250
AB	0.490	0.510		.500	.500	.500	.500	.500
AC	0.140	0.160		.153	.150	.152	.152	.152
AD	3.510	3.530		3.520	3.518	3.519	3.520	3.521
AE	1.633	1.673		1.658	1.656	1.658	1.659	1.660
AF	1.493	1.513		1.503	1.502	1.503	1.503	1.503
AG	0.040	0.060		.048	.046	.048	.047	.047
AH	0.188	0.193		.188	.188	.188	.188	.188
AI	0.140	0.160		.154	.154	.155	.158	.155
AJ	2.518	2.538		2.528	2.528	2.528	2.528	2.528
AK	0.040	0.060		.052	.050	.050	.050	.050
AL	0.010	0.020		.010	.010	.010	.010	.010
AM	0.140	0.160		.158	.158	.160	.160	.160
AN	0.350	0.450		.360	.360	.370	.365	.365
AO	0.240	0.260		.250	.250	.250	.250	.250
AP	0.150	0.170		.155	.155	.155	.158	.158
AQ	0.053	0.073		.063	.063	.063	.063	.063
AR	101.64	105.64		103.64	103.64	103.64	103.64	103.64
AS	0.260	0.267		.262	.262	.262	.262	.262
AT	0.053	0.073		.062	.063	.063	.063	.063
AU	4.118	4.138		4.130	4.128	4.128	4.128	4.128
AV								
AW								
Accept/Reject								

Measured by:	mk	Date:	18/06/10
Audited by:	A.e	Date:	18-06-12
Prototype Approval:		Date:	

Rev	Date	Change	Revised by	Approved
A	02.12.12	New Issue	KJ/RF	
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HAAS Section								
AA	0.240	0.260		.250	.250			
AB	0.490	0.510		.500	.500			
AC	0.140	0.160		.155	.150			
AD	3.510	3.530		3.520	3.520			
AE	1.633	1.673		1.656	1.657			
AF	1.493	1.513		1.502	1.502			
AG	0.040	0.060		.053	.044			
AH	0.188	0.193		.188	.188			
AI	0.140	0.160		.147	.151			
AJ	2.518	2.538		2.528	2.528			
AK	0.040	0.060		.052	.052			
AL	0.010	0.020		.010	.010			
AM	0.140	0.160		.157	.157			
AN	0.350	0.450		.374	.370			
AO	0.240	0.260		.250	.250			
AP	0.150	0.170		.151	.157			
AQ	0.053	0.073		.063	.063			
AR	101.64	105.64		103.64	103.64			
AS	0.260	0.267		.262	.262			
AT	0.053	0.073		.063	.063			
AU	4.118	4.138		4.131	4.130			
AV								
AW								
Accept/Reject								

Measured by: <i>gmk</i>	Date: <i>18/06/10</i>
Audited by: <i>B.e</i>	Date: <i>18-06-12</i>
Prototype Approval:	Date:

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